

Work Order ID 62831

Friday, October 08, 2010 12:49:22 PM



Page 1

Item ID:	D3137-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	10/8/2010	Start Qty:	6.00		Cust Item ID:	
Required Date:	10/15/2010	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-10-8	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3137	Rev F								

100		BAND SAW	0.00			6	0		
	Bandsaw	Memo	0.00	H.A	10/11/24				
	Jeaspa Bandsaw	Cut blanks: (.500" x 2.000") 5.570" long							

110		HAAS CNC VERTICAL MACHINING #1	0.00			6	0		
	HAAS 1	Memo	0.00	H.A	10/11/29				
	HAAS CNC vertical machine #1	1-Machine D3137-7 as per Folio FA3308and Dwg D3137 Identify as D3137-7 2-Deburr3-Scribe batch number							

120		QC2- Inspect parts off machine FAI/FAIB	0.00			6	0		
	QC	Memo	0.00	H.A	10/11/29				
	Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Page 2

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>ent 10/12/01</i>		<i>6</i>	<i>2</i>		
140  Small Fab Small Fab	Small Fab Memo Assemble D3137-043 as per Dwg D3137	0.00 0.00							<i>EP 10/12/14 (6)</i>
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>8 10/12/14</i>		<i>(46)</i>			

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Friday, October 08, 2010 12:49:22 PM



Page 3

Item ID: D3137-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 10/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>230B</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
170	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 12:49:26 PM

Page 1

Work Order ID: 62831

Parent Item: D3137-043

Parent Item Name: Bracket Assembly




Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 04.02.18 New issue KJ/DS
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24694-S101  Screw		Purchased	No			100	Each	54.0000	1	6		10/12/14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST290A				54					
				110363				54		6			
D3137-3  Guide		Manufactured	No			140	Each	6.0000	1	6		10/12/14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				6					
				62560				6					
D3137-5  Washer		Manufactured	No			140	Each	6.0000	1	6		10/12/14	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				6					
				46740				1					
				61701				5					

~~568~~ B63875 (6x)
B63873 (6x)
B59045 (2x)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 2

Friday, October 08, 2010 12:49:26 PM

Work Order ID: 62831



Parent Item: D3137-043



Parent Item Name: Bracket Assembly

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 6.00

Required Qty: 6.00

M174B0.500X02.000

Purchased

No

140

f

59.3351

0.4643

2.932421



17-4 SS Bar .500 x 2.00

Location

Loc Qty

Loc Code

MAT030

59.3351

100843

10.2

103089

18.5

14932

26

✓ 19572

4.6351

2.9324

ft

J.A 10/11/24

Friday, October 08, 2010 12:49:26 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 62831
Description: BRACKET ASSEMBLY		Part Number: D3137-7
Inspection Dwg: D3137 Rev: F		Page 1 of 1

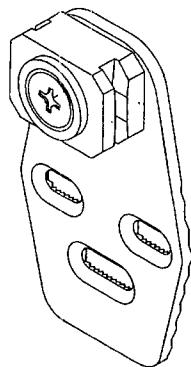
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.950	+/- .010	0.945	✓		Vern	GA-01
Ø 0.560	+/- .010	Ø 0.560	✓		"	"
0.67	+/- .030	0.667	✓		"	"
0.56	+/- .030	0.555	✓		"	"
0.77	+/- .030	0.760	✓		"	"
1.90	+/- .030	1.890	✓		"	"
1/4-28 UNF 3B	N/A	1/4-28 UNF 3B	✓		ref.	ref.
0.360	+/- .010	0.360	✓		Vern	GA-01
0.262	+/- .010	0.258	✓		"	"
0.062	+/- .010	0.062	✓		Vern	GA-01
R0.062	+/- .010	R0.062	✓		R-6	ref
0.162	+/- .010	0.156	✓		Vern	GA-01
4.850	+/- .010	4.850	✓		H-6	31006
2.360	+/- .010	2.360	✓		H-6	31006
1.880	+/- .010	1.880	✓		"	"
0.318	+/- .010	0.313	✓		Vern	GA-01
Ø 0.500	+0.006/- .001	Ø 0.500	✓		"	"
0.032	+0.000/- 0.010	0.030	✓		D-6	GA-08
0.200	+/- .010	0.199	✓		Vern	GA-01
0.235	+/- .010	0.233	✓		"	"
0.076	+/- .010	0.075	✓		"	"
100°	+/- 1/2°	100°	✓		A-M	CVC-03

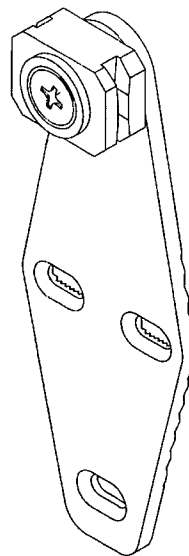
Measured by: J.A.	Audited by: <i>aml</i>	Preliminary Approval:
Date: 10/11/29	Date: 10/12/01	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	P/O D3137-043	KJ

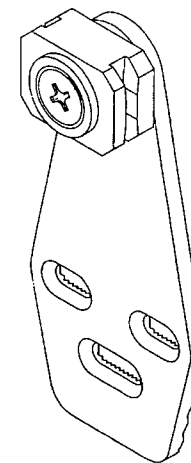
10.04.15



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

STICK
REVIEW
ENGINEER
UNCONTROLLED
SUSPECTED
NO. *C2831*
BS10-10-8

RELEASED
06062107

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.38 WAS 2.48, ZONE A.4 0.480 DIM WAS 0.605, ZONE A.8 0.67 DIM WAS 0.78, ZONE B.5 4.850 DIM WAS 4.975 & ZONE B.8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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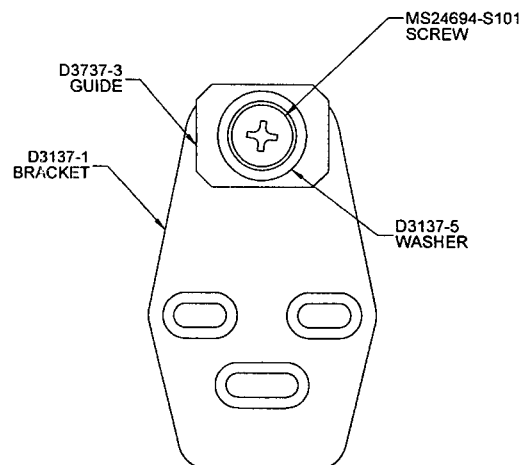
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

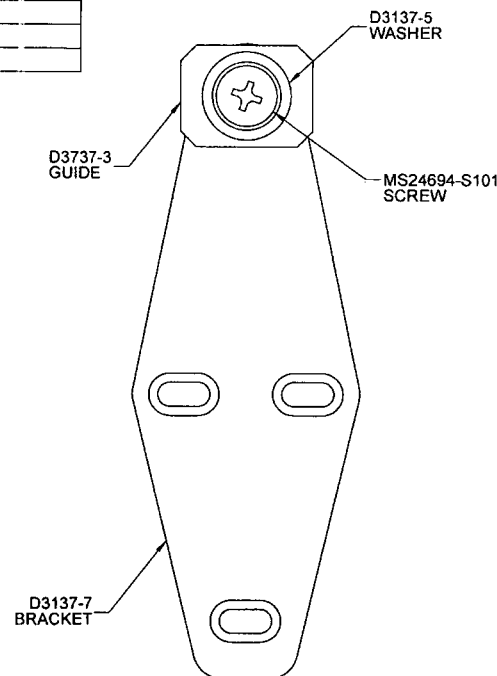
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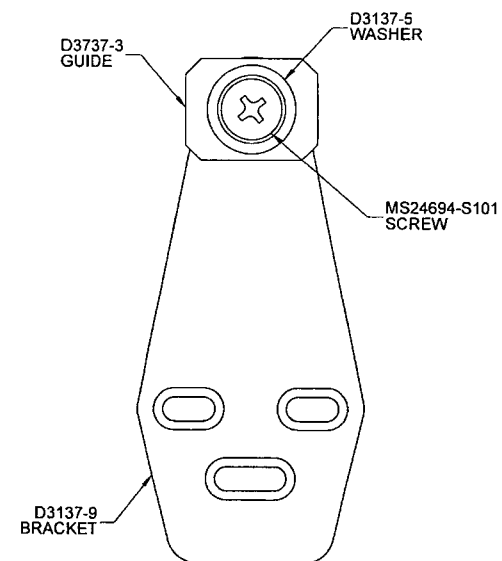
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
: 0.32 lbs -043
: 0.27 lbs -045

RELEASED
08.06.26/10

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

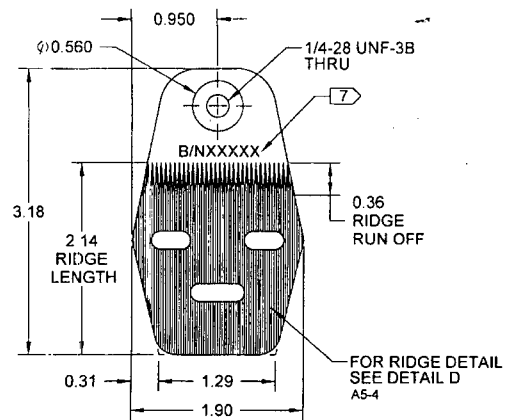
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

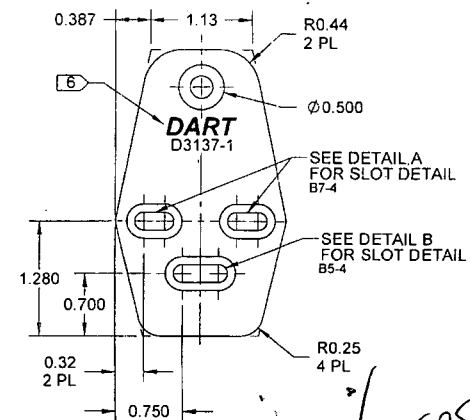
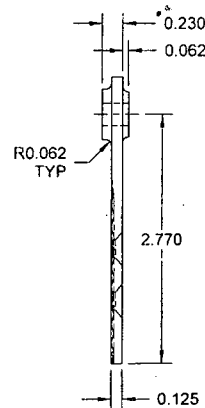
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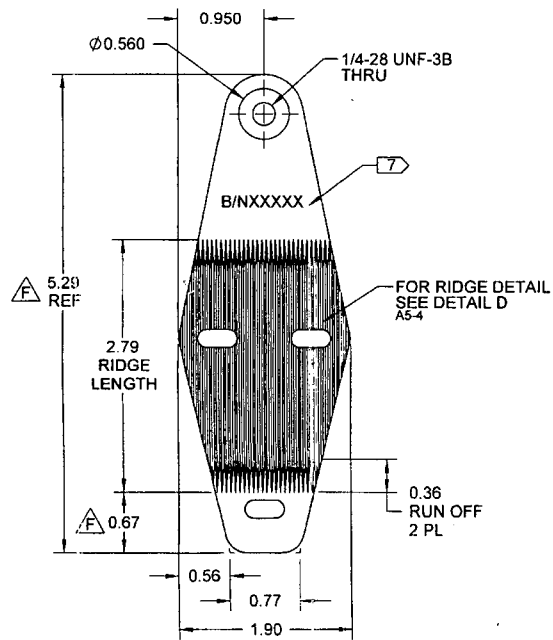
NOTE: Date & initial all entries



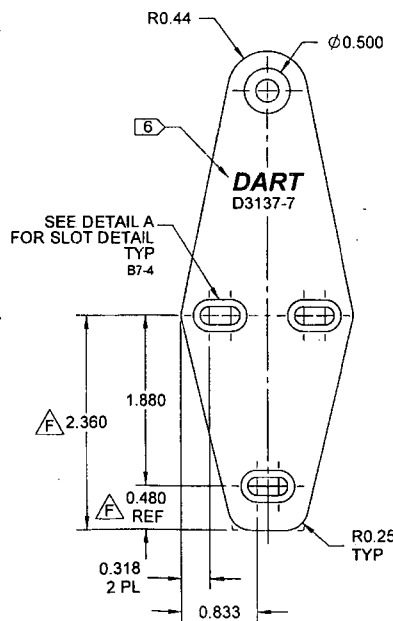
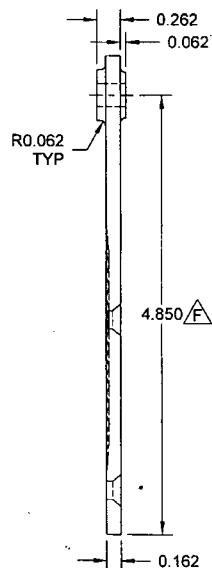
D3137-1 BRACKET



w/o 62831



D3137-7 BRACKET



NOTES:

- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-1

RELEASED
CH 06-26 1/10

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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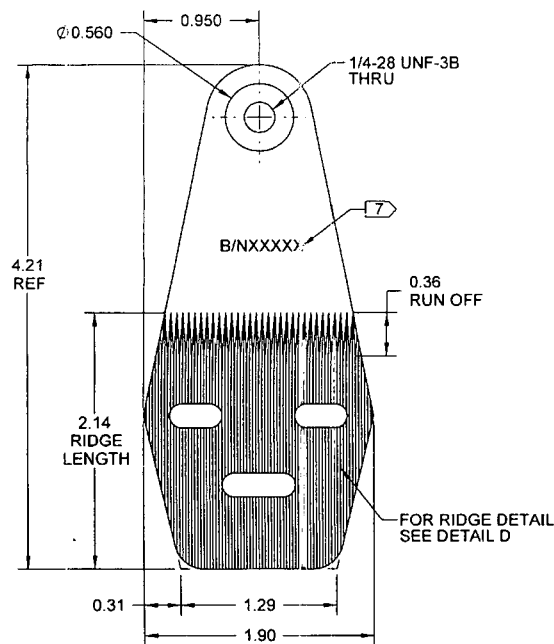
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

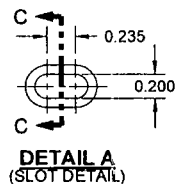
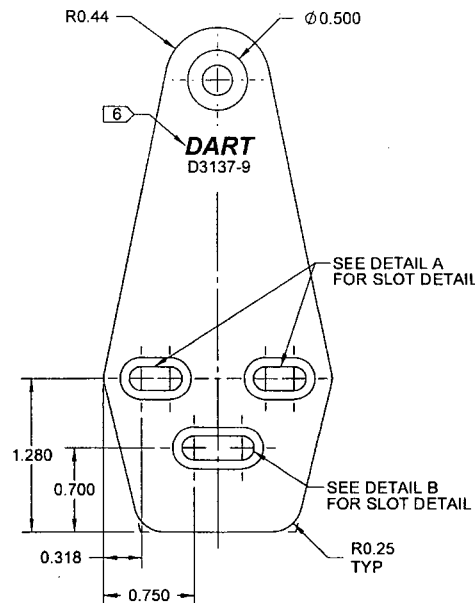
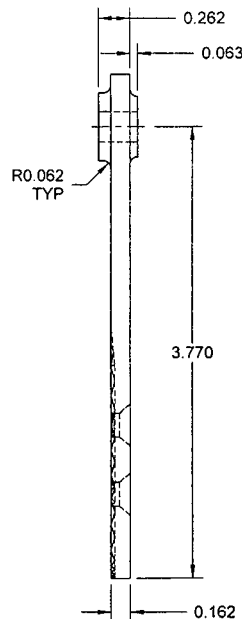
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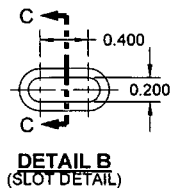
NOTE: Date & initial all entries



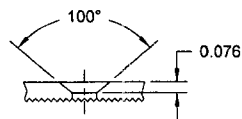
D3137-9 BRACKET



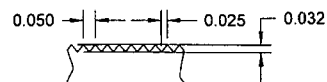
**DETAIL A
(SLOT DETAIL)**



**DETAIL B
(SLOT DETAIL)**



**SECTION C-C
(SLOT DETAIL)**



**DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)**

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
08-06-36 MP

W/O 62531

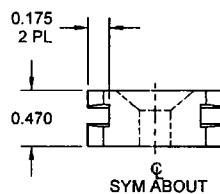
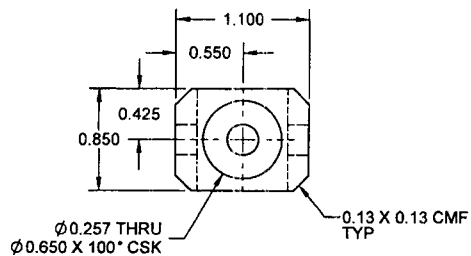
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

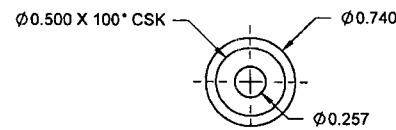
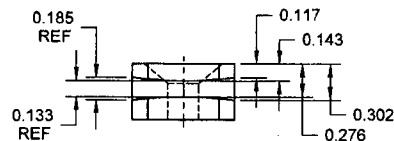
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

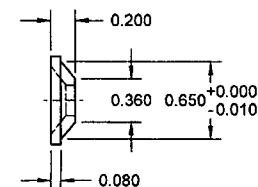
NOTE: Date & initial all entries



D3137-3 GUIDE



D3137-5 WASHER



w/o 4283

NOTES:

- 1) MATERIAL: -3
DELTRIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELTRIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED
(80702/14)

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries